



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Work Order ID 63449**

Tuesday, November 02, 2010 9:21:41 AM



Page 2

Item ID: D4148-3

Accept



Setup

Start



Revision ID:

Item Name: Stud Receiver, Lower

Stop



Start Date: 11/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

4  
8

QC

Quality Control

Memo

0.00

10/11/08

130



QC8- Inspect parts - second check

0.00

4  
8

QC

Quality Control

Memo

0.00

M. A 10/11/09

170



Identify as per dwg &amp; Stock Location:

Sylvie  
133

0.00

10/11/09 4

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63449**

Page 3

Tuesday, November 02, 2010 9:21:41 AM

Item ID: D4148-3

Accept



Setup Start



Revision ID:

Item Name: Stud Receiver, Lower

Stop



Start Date: 11/2/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

  
  
 10-11-9

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Tuesday, November 02, 2010 9:21:44 AM

Page 1

Work Order ID: 63449



Parent Item: D4148-3



Parent Item Name: Stud Receiver, Lower

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X03.000		Purchased		No		100	f	11.5200	0.48	0.96			

303 BAR 1" X 3'



Location	Loc Qty	Loc Code
MAT	11.52	
115555	11.52	

1.92 amf 10/11/04

W/O:		WORK ORDER CHANGES							
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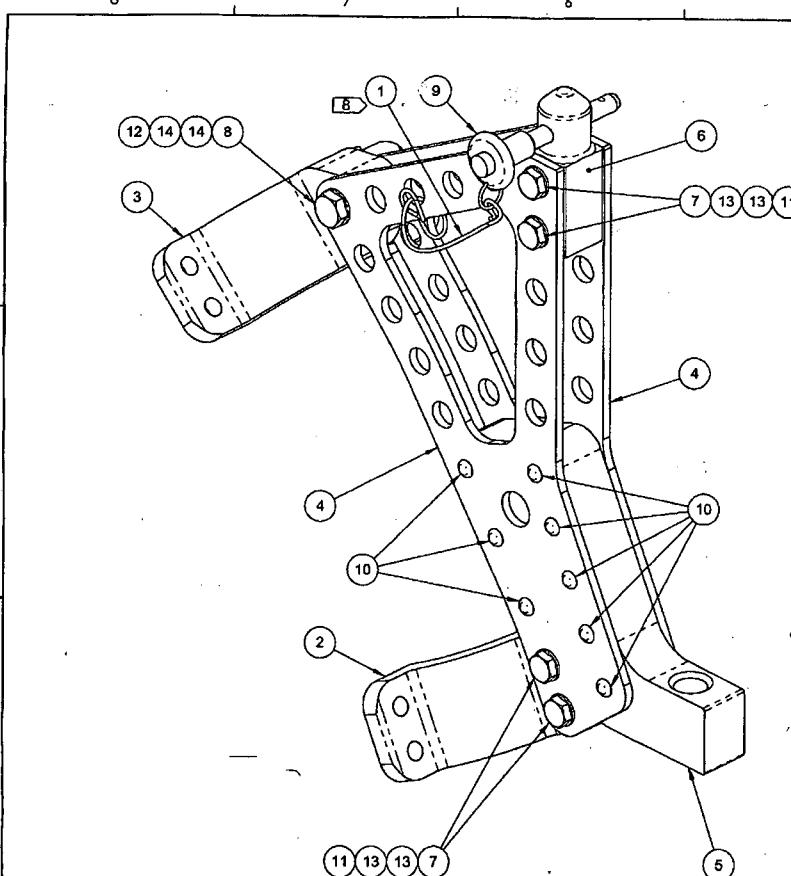
DART AEROSPACE LTD	Work Order:	63442
Description: <u>Sled Receiver</u>	Part Number:	A4148-3
Inspection Dwg: <u>A4148</u> Rev: <u>C</u>		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by:		Audited by:	B. A	Preliminary Approval:	
Date:	, 01/11/08	Date:	10/11/09	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



**D4148-041 FWD X-TUBE LUG ASSY**

**A NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.63 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. *63419*

*28/10/10-02*

**RELEASED**  
2010-10-28  
*JK*

C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-51 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS M4.0 X 0.129 INCHES (ZIN D6-3); Q0.129 PL REPLACES Q0.129 3 PL (ZIN D6-3); Q0.129 7 PL WAS 10 PL (ZIN A7-3); Q0.191 WAS 0.129 (ZIN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JK</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JK</i>	DRAWING NO. <b>D4148</b> REV. C SHEET 1 OF 5	
CHECKED	<i>JK</i>	MFG. APPR.	
APPROVED	<i>JK</i>	TITLE <b>FWD X-TUBE LUG ASSY</b> SCALE NTS	
DE APPR.	<i>JK</i>	DATE <b>10.10.12</b>	

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WRITTEN APPROVAL FROM DART AEROSPACE LTD

ITEM	QTY -041	P/N	DESCRIPTION
X	D4148-041		FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	4	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	4	MS21043-3	NUT
12	1	MS21043-4	NUT
13	8	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER

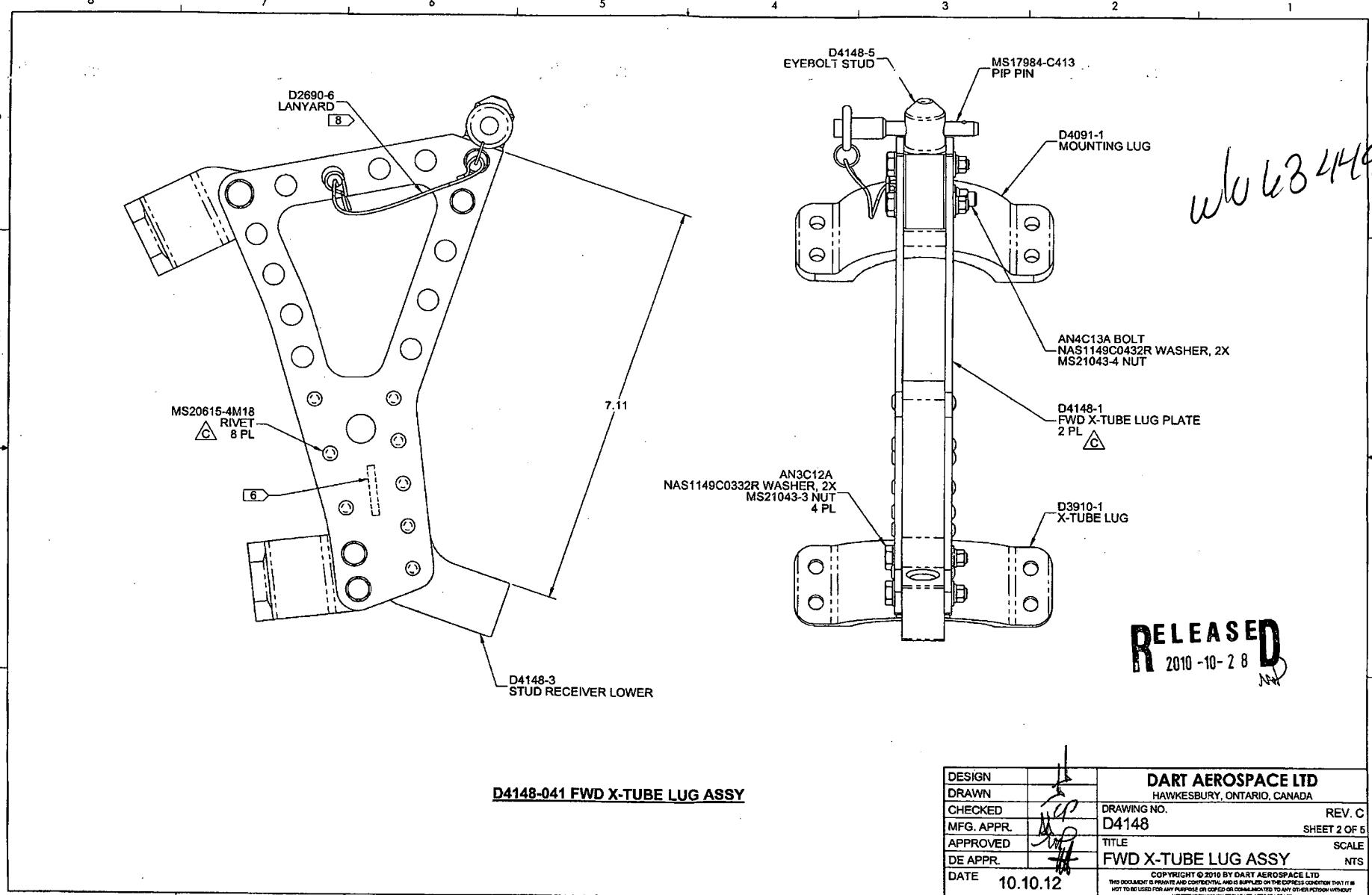
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NOTE: Date & initial all entries



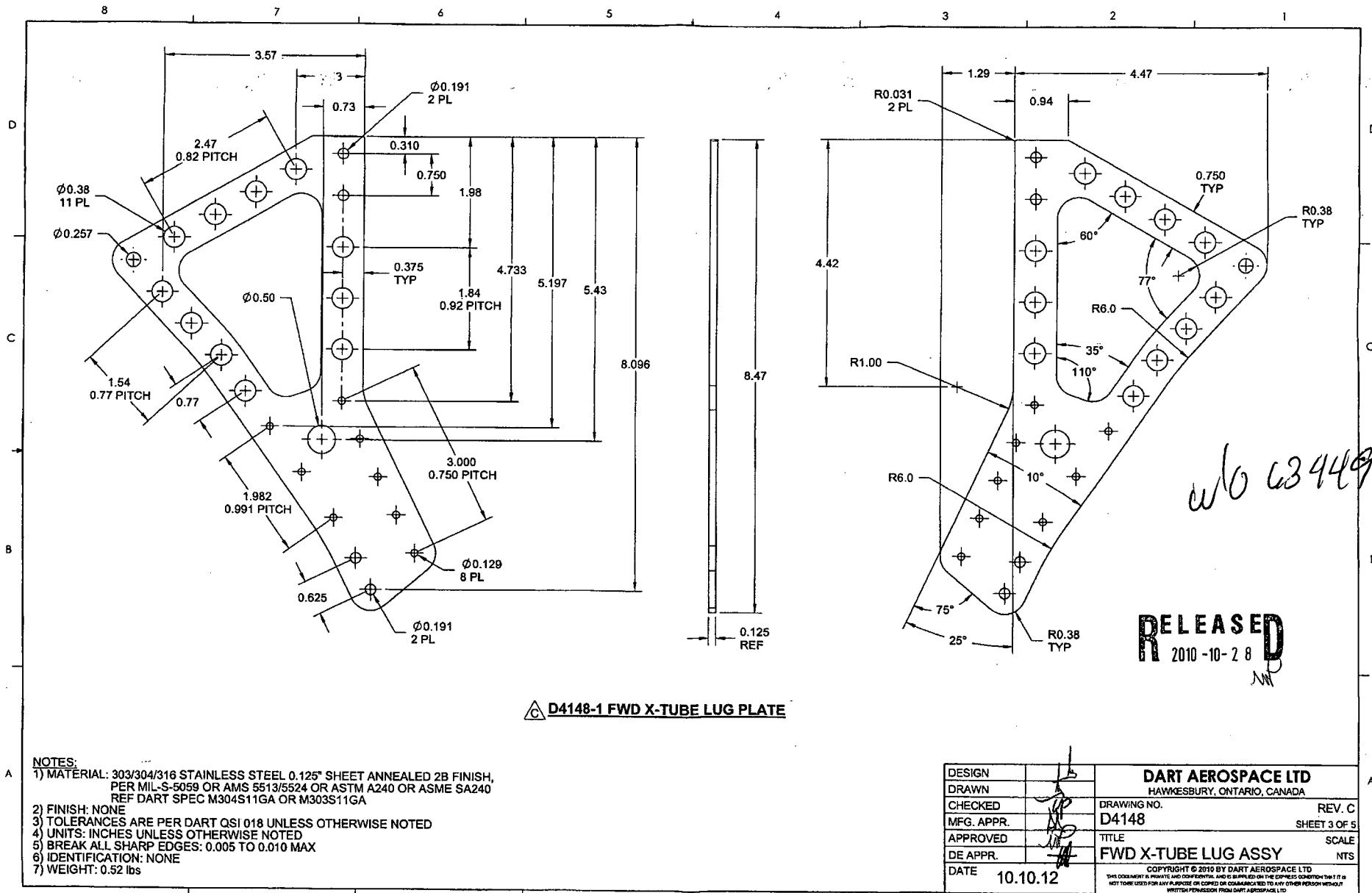
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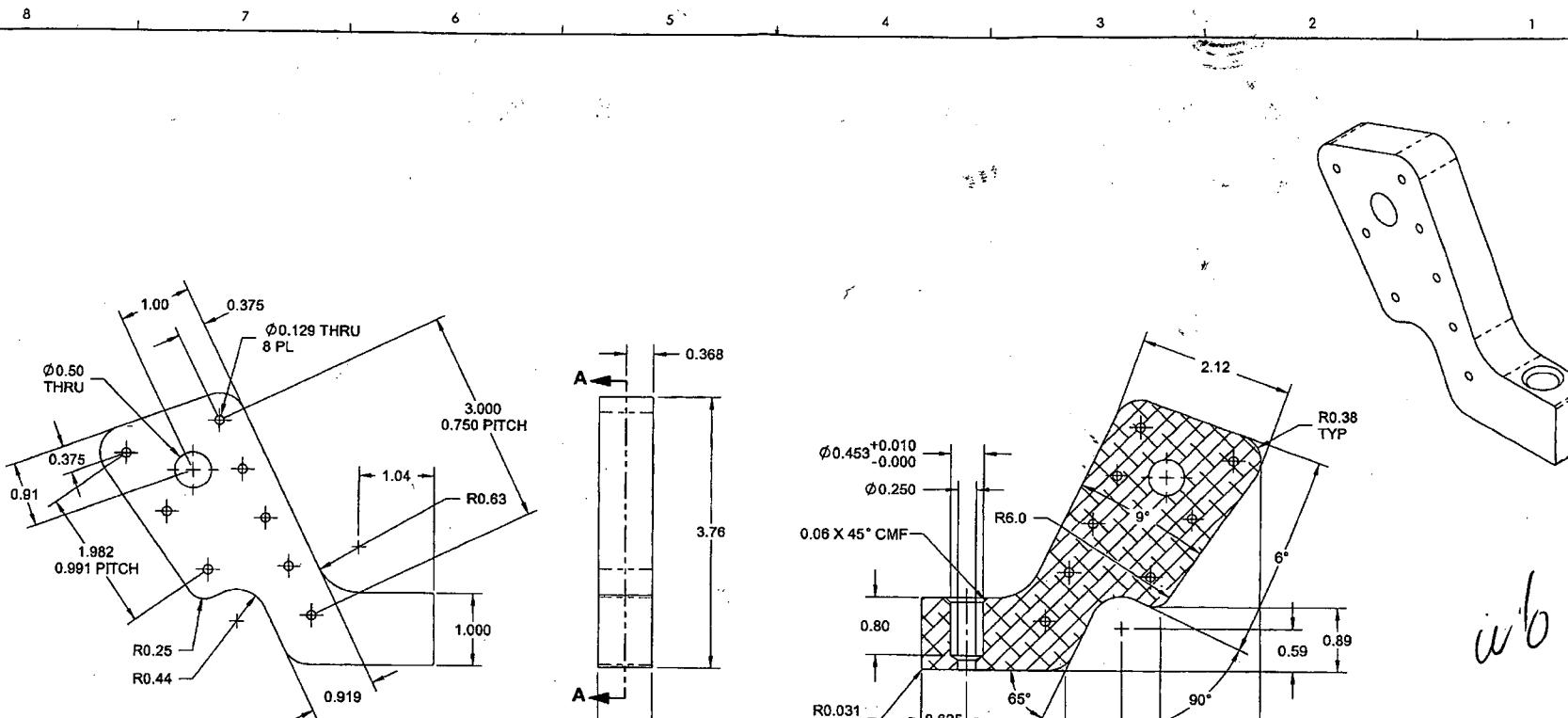
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NOTE: Date & initial all entries



△ D4148-3 STUD RECEIVER LOWER

SECTION A-A

RELEASED  
2010-10-28

A NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. C
MFG. APPR.		D4148
APPROVED		SHEET 4 OF 5
DE APPR.		TITLE
DATE	10.10.12	SCALE
		FWD X-TUBE LUG ASSY
		NTS

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NOTE: Date & initial all entries

8

7

6

5

4

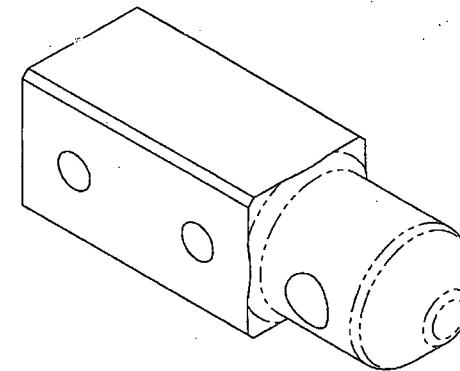
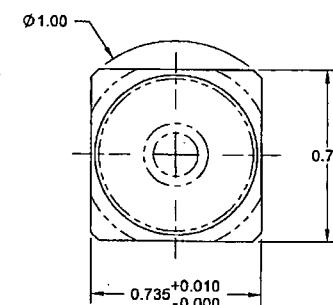
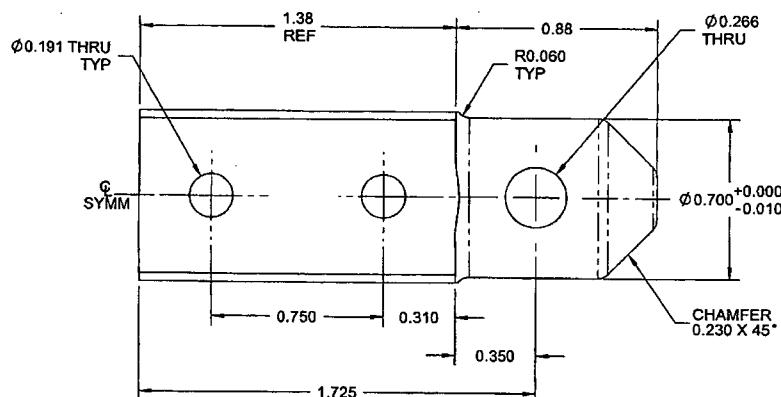
3

2

1

D

D



W/0 434129

D4148-5 EYEBOLT STUD

A NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

8

7

6

5

4

3

2

1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D4148 REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE FWD X-TUBE LUG ASSY
DE APPR.	<i>[Signature]</i>	SCALE NTS
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